

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018230**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB018-098-043 and 055 located on Suspender Bracket SB098W. ZPMC Welder is identified as 062807. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB021-102E-037 and 043 located on Suspender Bracket SB102E. ZPMC Welder is identified as 062783. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB021-102-005 located on Suspender Bracket SB102E. ZPMC Welder is identified as 062788. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB021-102-001 located on Suspender Bracket SB102E. ZPMC Welder is identified as 062783. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC

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appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on stringer plate of the OBG Bike Path BK005A-002.

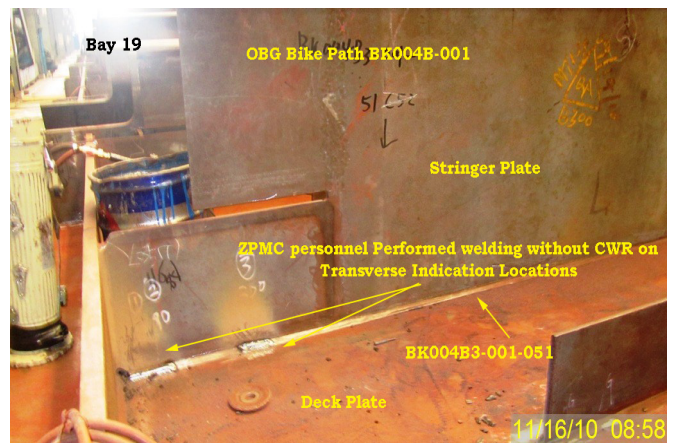
Description of Incident: During the Caltrans Quality Assurance in-process observations of the fabrication of Bike Path, this Quality Assurance Inspector (QA) observed that ZPMC personnel performing weld repair of three (3) Transverse Indication, without the prior approval of the Engineer or an approved CWR. The three (3) Transverse Indications measuring approximately 8mm to 12mm in length, found by ZPMC personnel as on 11/11/2010 and this weld number is identified as BK004B3-001-051. This weld is fillet weld joint, joining stringer plate (BKX8C) to Deck Plate (BKPL1A). This weld is designated as Non Seismic Performance Critical Member (Non SPCM). ZPMC personnel completed weld repairs on BK004B3-001-051 joint by SMAW welding without prior Engineer approval or utilizing an approved Critical Weld Repair Report (CWR). For your information in same Bike Path BK004B-001, another forty one (41) Transverse Indications measuring approximately 10mm to 15mm in length, found by ZPMC personnel at the weld joint: BK004B3-001-052 as on 11/10/2010. Repair for this weld also required Critical Weld Repair Report (CWR). This OBG Bike path is located in OBG fabrication shop Bay #19. The ZPMC QC is identified as Mr. Guo Xing Hui.

Visual Inspection after Blast

OBG Segment 12AW

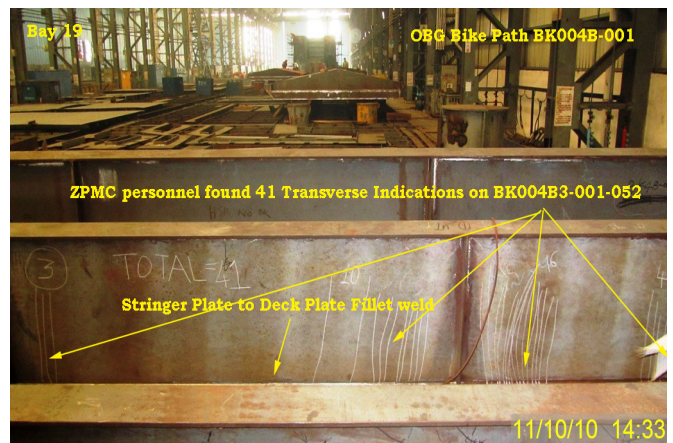
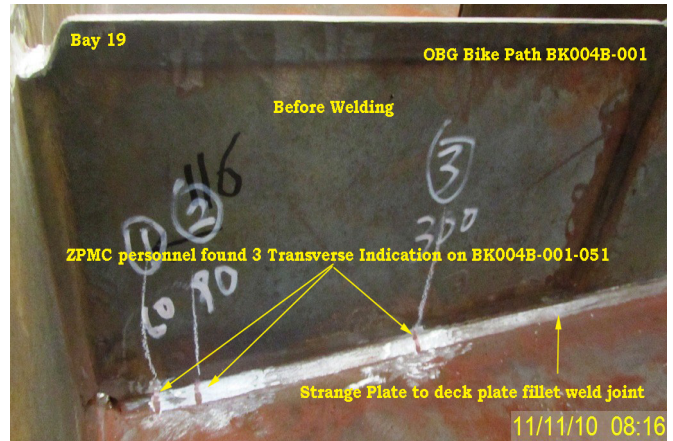
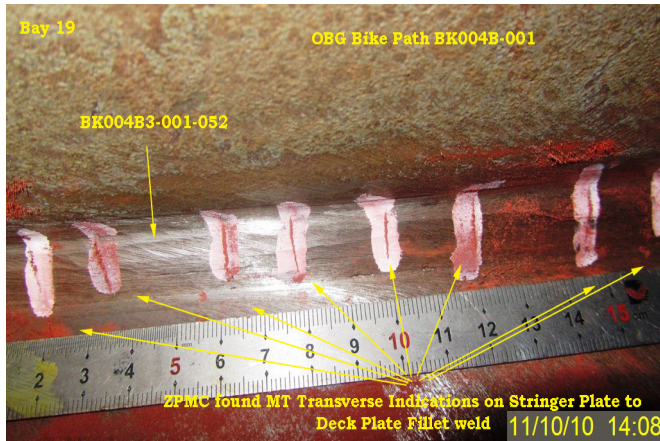
This QA Inspector performed a preliminary random visual inspection on OBG Segment 12AW, after the grit blast of the exterior components of the deck planes, floor beams, bottom plates, side plates and corner assemblies of this segment panel point PP109 to P112. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer